

Ship Friday

24/7/09

## Work Order ID 50782



Page 1

July 22, 2009 12:46:51 PM

Item ID: D3890-041

Accept



Setup Start



Revision ID: A

Item Name: Panel, Side

Stop



Start Date: 07/22/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 07/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 09-07-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3890

A

(4)

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3890-1

Dwg Rev: A

Prog Rev: A

18 9-7-23

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

18 9-7-23



QC

Memo

0.00

Quality Control

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

⇒ 807/7/23

(4)

φ

130



Small Fab

Small Fab

Memo

Deburr if necessary

0.00

0.00

(4X) m-k 09/07/23

140



Thermoform

Thermoforming Machine

Memo

Thermoform using mold DT9489 as per dwg

0.00

0.00

el. 09/07/23 (4X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description - Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50782

July 22, 2009 12:46:51 PM

Page 3

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Item Name: Panel, Side

Setup Start

Stop

Start Date: 07/22/2009 Start Qty: 4.00

Required Date: 07/24/2009 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 802/07/23

(44)

f

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

6/2/23

170

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond gasket to smooth side of panel as per dwg  
A/R 3M 1300 adhesive Batch: A11428

M-1 09/07/23

(4X)

P12 ->

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3890-041 PAR #: N/A Fault Category: Sm. fab. NCR ☒ Yes No DQA: ll Date: 09-07-27  
 Disp: use as is / Resolution: acceptable QA: N/C Closed: / Date: 09-08-19

NCR: <u>50782</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/7/24	#170	<del>ALL</del> AC 4 Parts have the cylinder D3890-3 are not placed to Dwg.	PH 09.07.24 QSF 042	ACCEPTABLE - NON STRUCTURAL DEVIATION - NO FIT AND FUNCTION PROBLEMS	M.H. 09/07/24	S 09/07/24	PH 09.07.24 QSF 042	S 09/07/24
	Small FAB	R.C. employee thought it Read ".025". Dwg. is Clean @ .25".	↓	↓	/	/	↓	S 09/07/24

NOTE: Date & initial all entries

# Work Order ID 50782

July 22, 2009 12:46:51 PM

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Item ID: D3890-041

Accept

Revision ID: A

Item Name: Panel, Side

Start Date: 07/22/2009 Start Qty: 4.00

Required Date: 07/24/2009 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

190



Packaging

Packaging

Identify as per dwg & Stock Location: 541P

0.00

Memo

0.00

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

6 9.8.24

Per 9/1/24 (4)

09/07/27

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

Page 1

July 22, 2009 12:46:51 PM

Work Order ID: 50782

Parent Item: D3890-041RevA

Parent Item Name: Panel, Side

Comments:

Start Date: 07/22/2009

Required Date: 07/24/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	709.8406	15.2337			



GE PLASTICS LEXAN SHEET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	709.8406316	
103106	7.8	
105330	54	
109455	0.03	
111710	648.010632	

D3890-3RevA

Manufactured No



Gasket

160 Each

0.0000 8.0000



111710 18 9-7-23

M 50782 m. 09/07/23 \*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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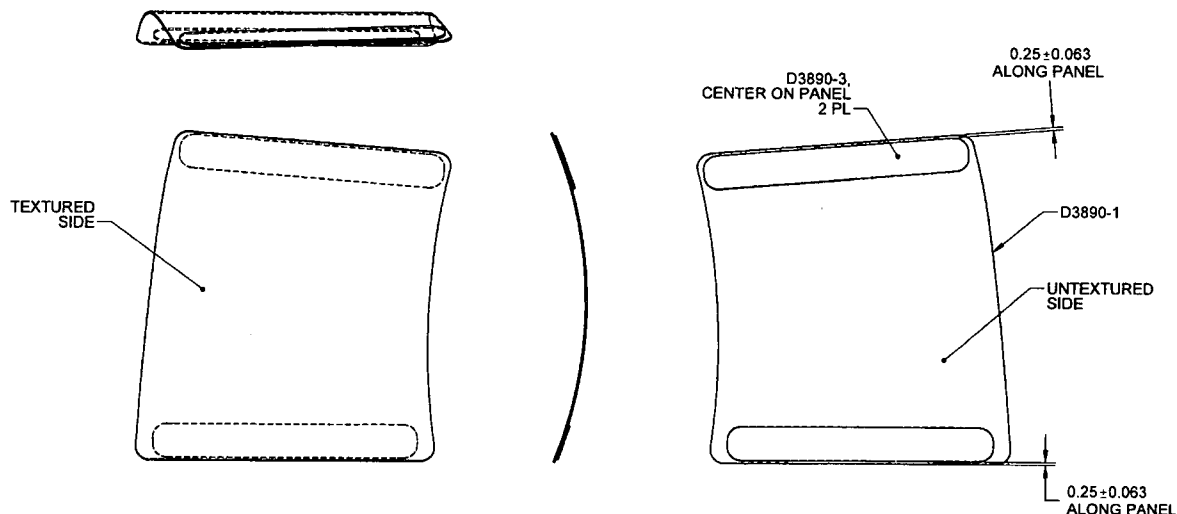
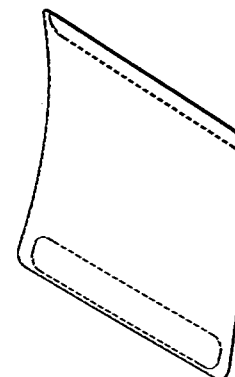
**NOTE:** Date & initial all entries



# PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3890-041	PANEL, SIDE
2	1	D3890-1	PANEL
3	2	D3890-3	GASKET
5	A/R	3M 1300	ADHESIVE

# 50782  
mf  
09-07-22



**D3890-041 PANEL, SIDE**

**RELEASED**  
09/25/16

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3890-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.48 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE.

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	GP		
CHECKED	PH		
MFG. APPR.	21		
APPROVED	14		
DE APPR.			
DATE	09.05.01		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3890** REV. A  
SHEET 1 OF 4  
TITLE **PANEL, SIDE** SCALE NTS

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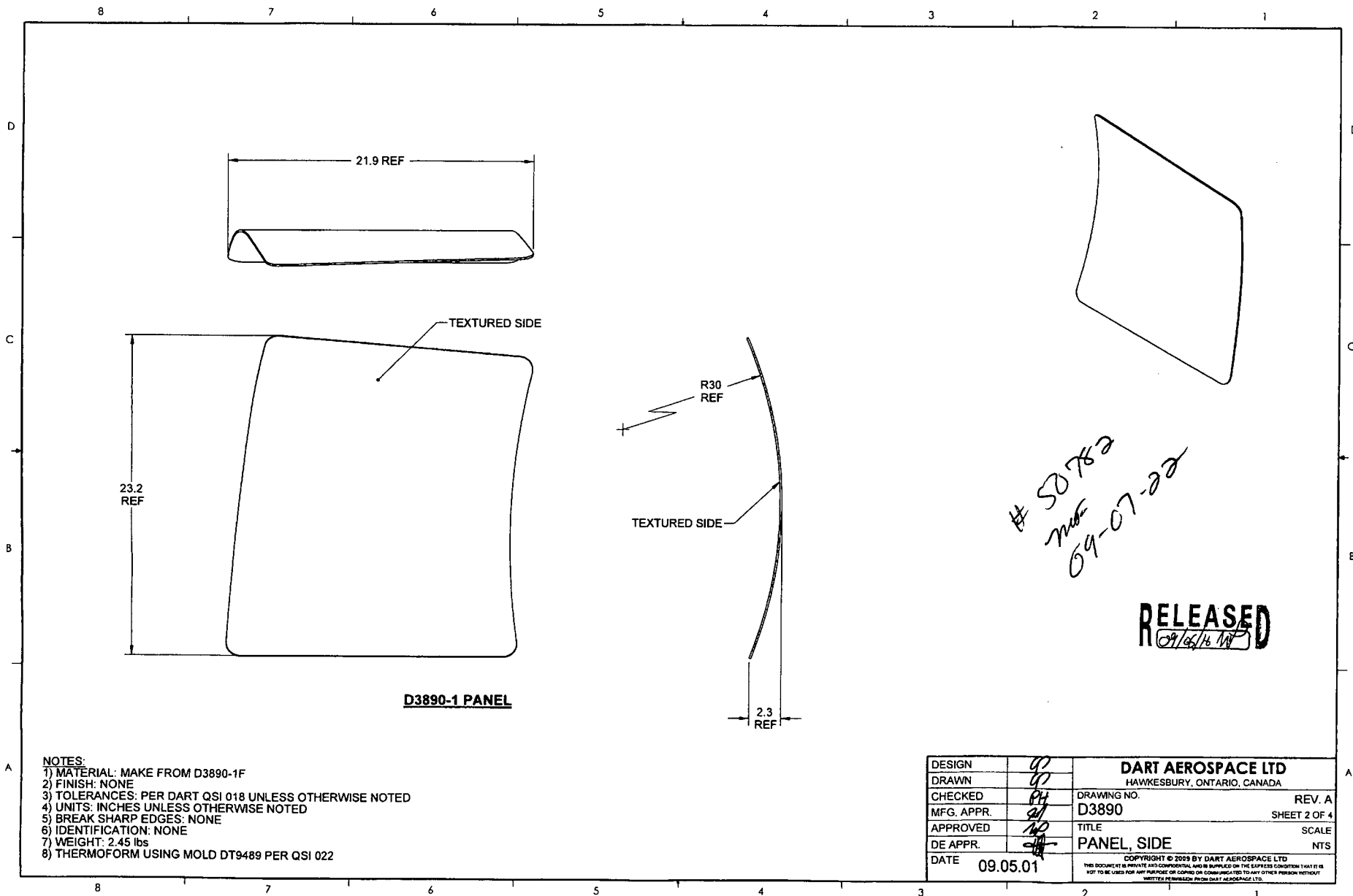
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



- NOTES:
- 1) MATERIAL: MAKE FROM D3890-1F
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: NONE
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 2.45 lbs
  - 8) THERMOFORM USING MOLD DT9489 PER QSI 022

DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3890	SHEET 2 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	11	PANEL, SIDE	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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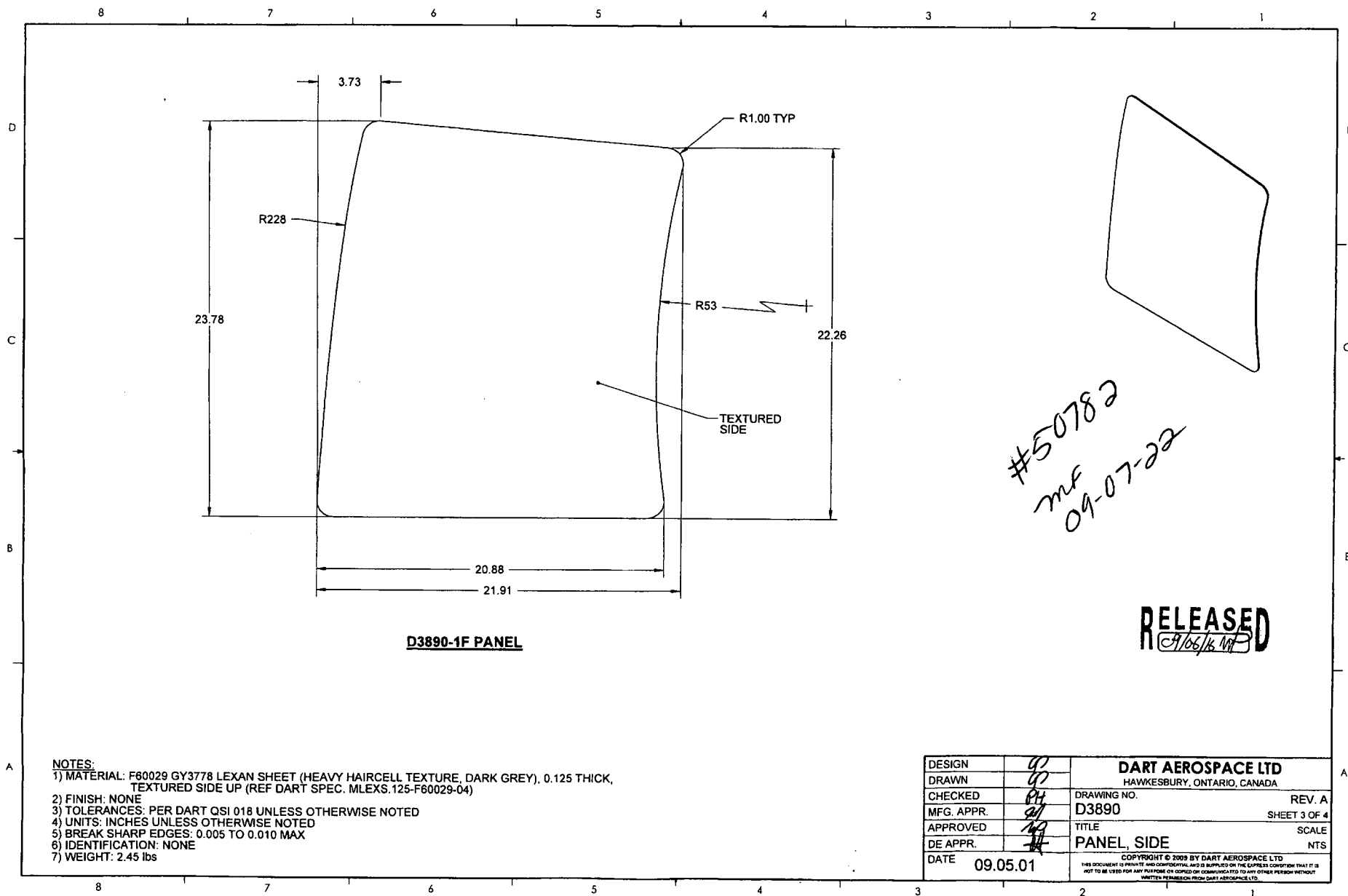
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**Dart Aerospace Ltd**

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